

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
 Job Number : 34251
 Estimate Number : 12951
 P.O. Number : N/A Part Number : D32593
 This Issue : 8/23/2007 S.O. No. : N/A Drawing Number : D3259 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A1
 Previous Run : N/A Material : N/A
 Written By : Due Date : 9/15/2007 Qty: 6 Um: Each
 Checked & Approved By : 07.08.23
 Comment : Est Rev: A New Issue 07-07-19 JLM Verified By: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 1.4574 sf(s)/Unit Total: 8.7444 sf(s)

~~2024-T3 .063 sheet~~ 2024-T3 063

Batch: 11104921 *6

SAD 07/08/26

P10

2.0 WATER JET ~~Scrap x1~~ FLOW WATER JET
Total = 7



Comment: FLOW WATER JET

1-Cut as per Dwg D3259

Dwg Rev: A1

Prog Rev: A1

2-Deburr if necessary / open hole 0.093"

SAD 07/09/04

SAD 07/08/26

P10

6

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/26

6

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 07/09/05

6

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C Sink Holes as per Dwg D3259

MF

07-09-21

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/28	1.0	Change mat. to match Dasg.D328-3-4 2024-T3-063 not 2024-T3-032	[Signature]	07-08-28	1	[Signature]	Er 07/08/28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 07/09/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/05	2.0	one part scrap - wrong GRAIN Direction R.C. Human Error	[Signature] Rasmuz	Scrap and destroy and replace	SAD 07/09/05	Er 07/09/05	[Signature] Rasmuz	Er 07/09/05

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 34251

Part Number: D32593

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3259

8B 07/09/20

(4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/24 (6) counter

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 07-09-24

(6)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/09/24 (6)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/09/24 (6)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/25 (6)

Job Completion



07-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

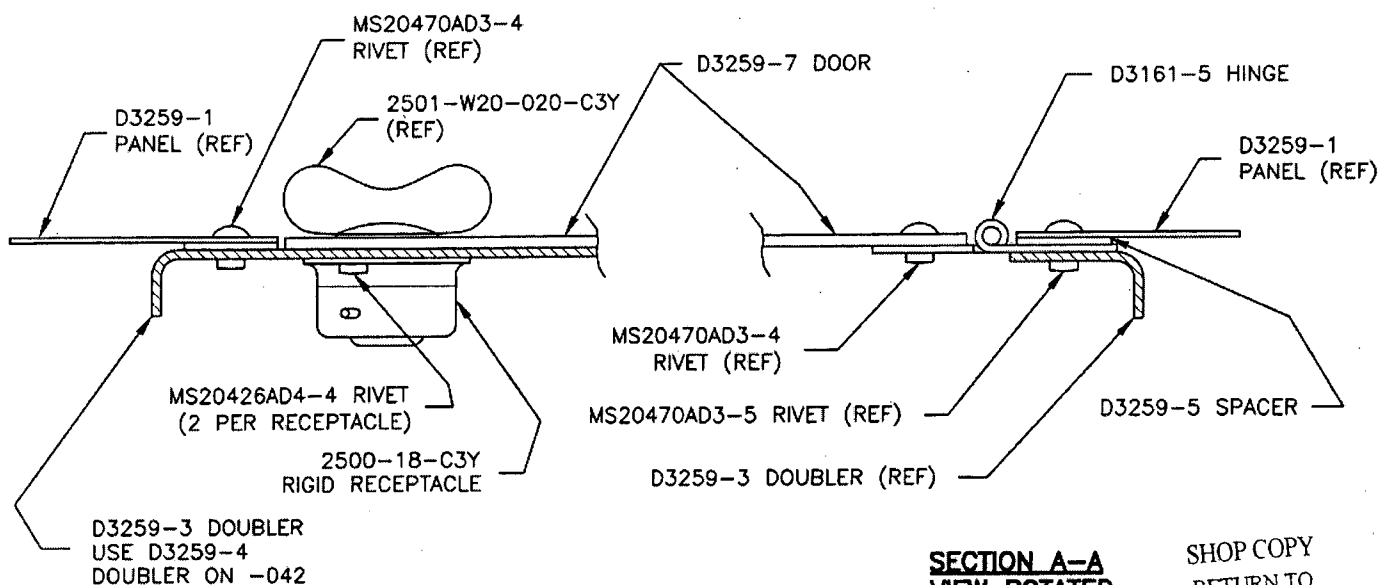
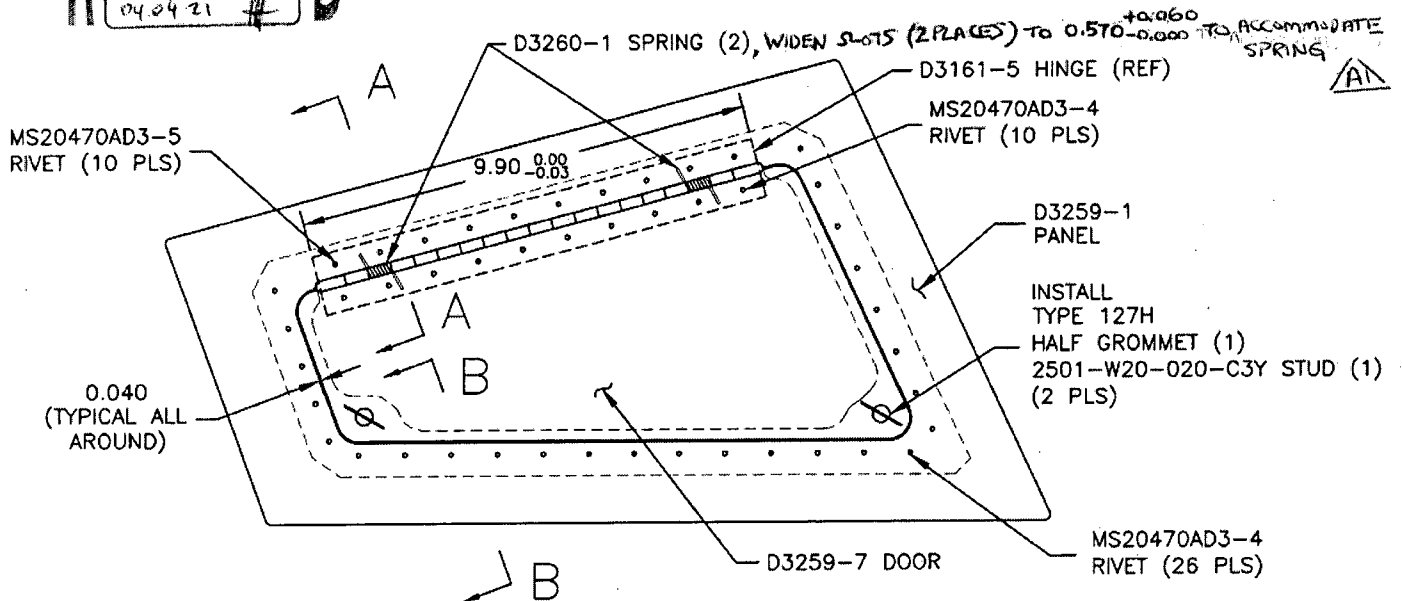
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. A
				D3259	SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE	1:4
A	04.02.25	NEW ISSUE			
A1	CP	04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING		

RELEASED
040421 #



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WITHOUT NOTICE

WORK ORDER

34251

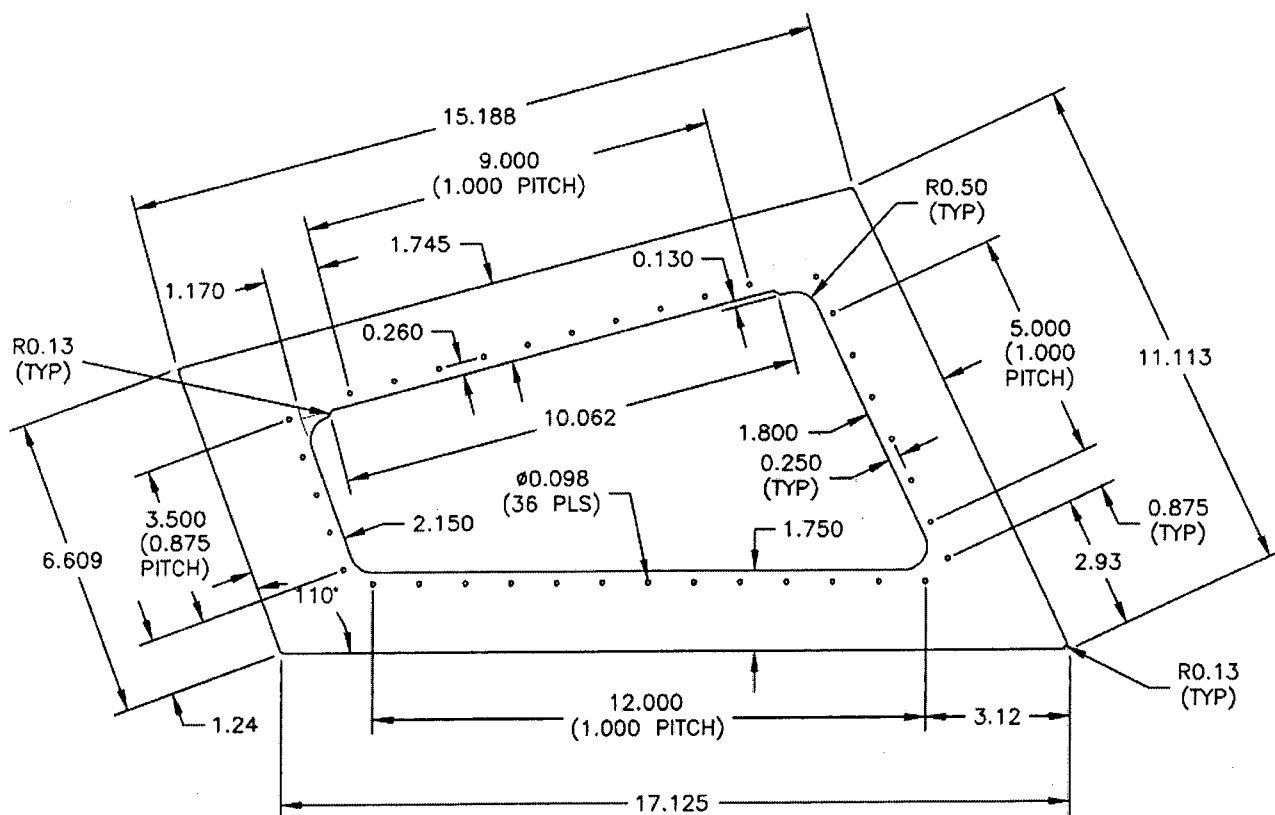
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CHECKED #	APPROVED #	DRAWING NO. D3259	REV. A SHEET 2 OF 6
DATE 04.02.25	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED
04.04.05



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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34251

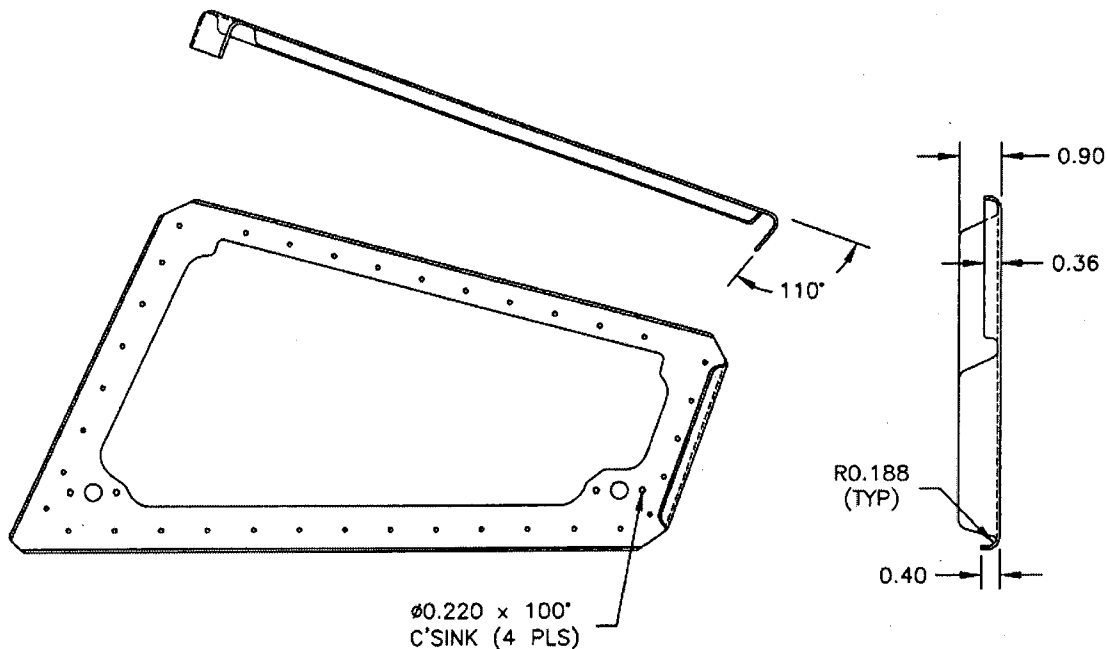
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-3 DOUBLER BEND DETAIL (SHOWN)

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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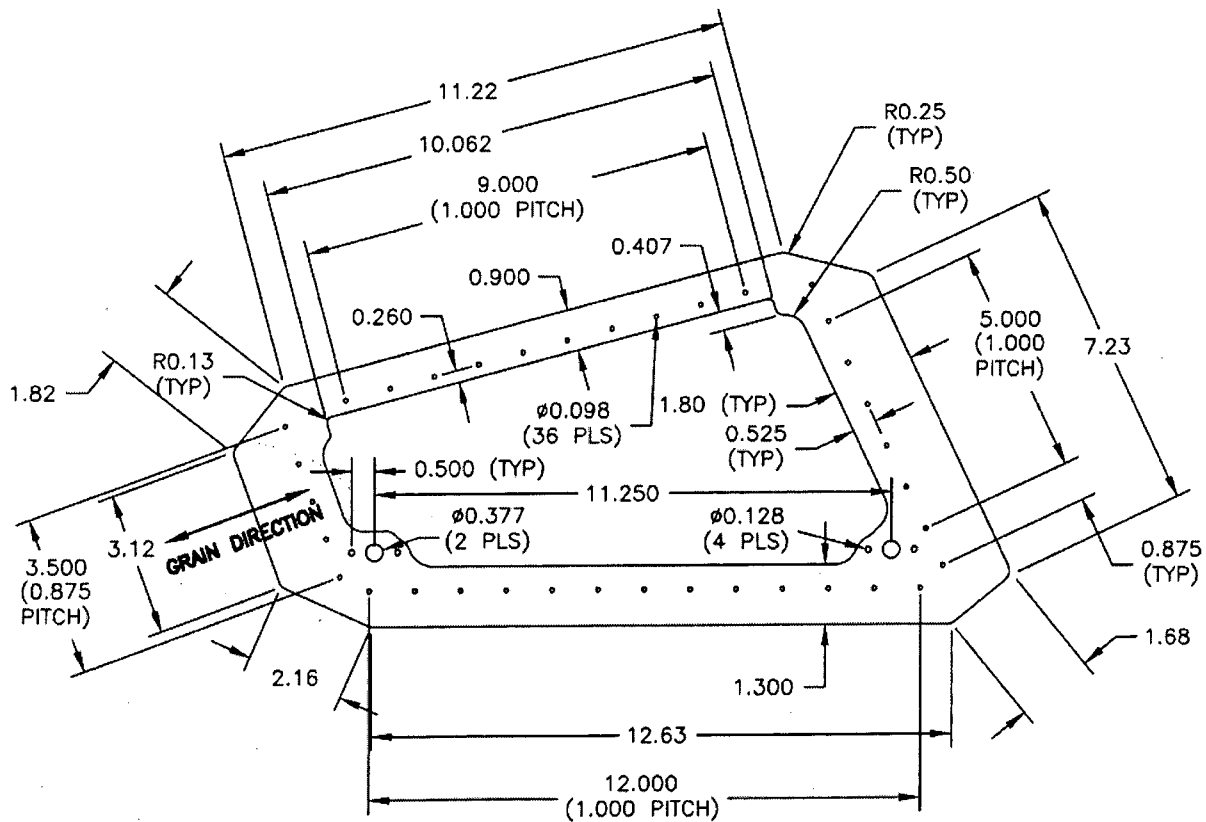
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04 04 14 *[Signature]*



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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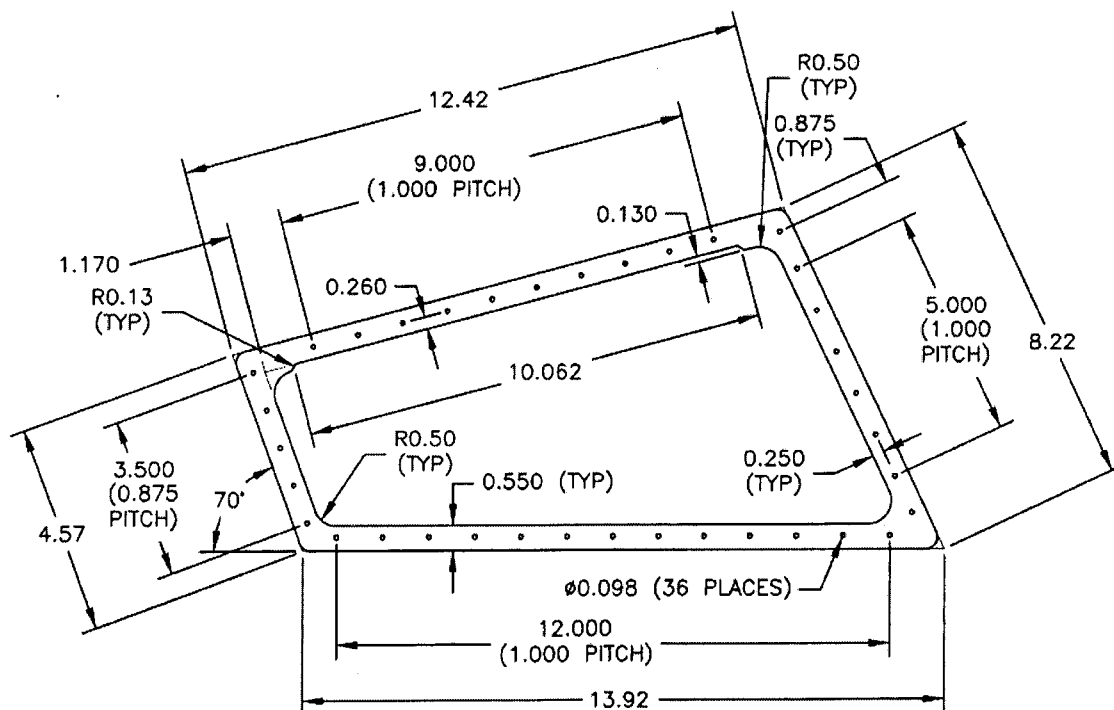
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DATE 04.02.25	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED
04.04.05 [Signature]



D3259-5 SPACER

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:





- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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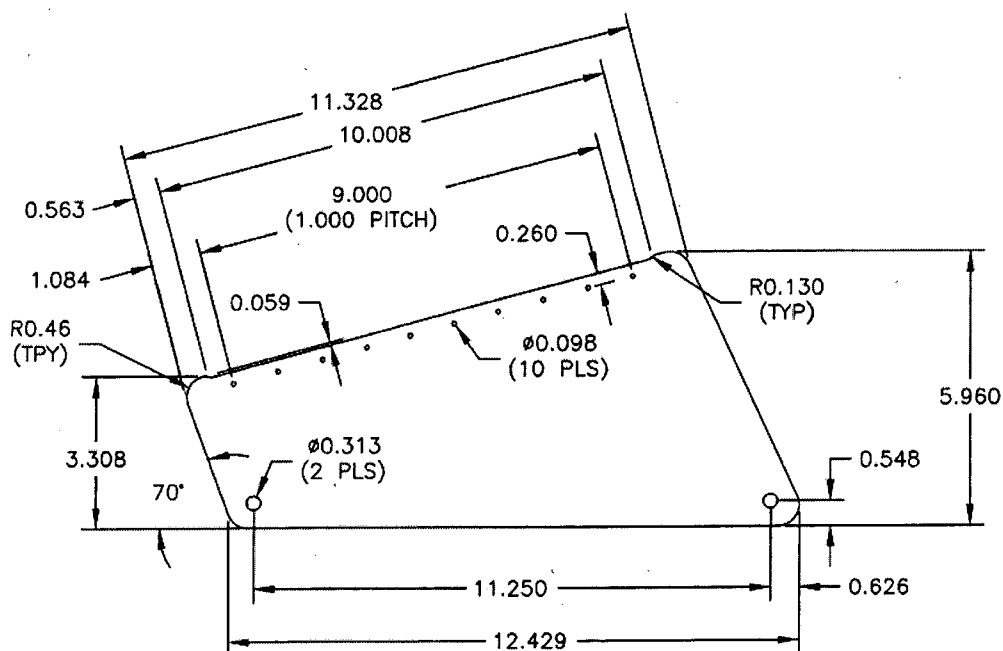
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RELEASED
04-04-14



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 34252
Description: Doubler		Part Number: 532594 D32593
Inspection Dwg: D 3259	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/- 0.010	9.004	✓		Vern	
1.000 (Pitch)	+/- 0.010	1.006	✓		Vern	
3.500	+/- 0.010	3.503	✓		Vern	
0.875 (Pitch)	+/- 0.010	0.882	✓		Vern	
12.000	+/- 0.010	12.000	✓		Vern	
1.000 (Pitch)	+/- 0.010	1.002	✓		Vern	
5.000	+/- 0.010	5.010	✓		Vern	
1.000 (Pitch)	+/- 0.010	1.006	✓		Vern	
1.80	+/- 0.030	1.81	✓		Vern	
0.525	+/- 0.010	0.530	✓		Vern	
11.250	+/- 0.010	11.259	✓		Vern	
1.300	+/- 0.010	1.310	✓		Vern	
0.260	+/- 0.010	0.270	✓		Vern	
0.900	+/- 0.010	0.908	✓		Vern	
Ø 0.128	+/- 0.005 -0.001	Ø 0.128	✓		Vern	
Ø 0.098	+/- 0.004 -0.001	Ø 0.099	✓		Vern	
Ø 0.377	+/- 0.006 -0.001	Ø 0.378	✓		Vern	
0.063	+/- 0.010					

Measured by: SAN	Audited by: En	Prototype Approval: <i>alr</i>
Date: 07/08/26	Date: 07/08/05	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	